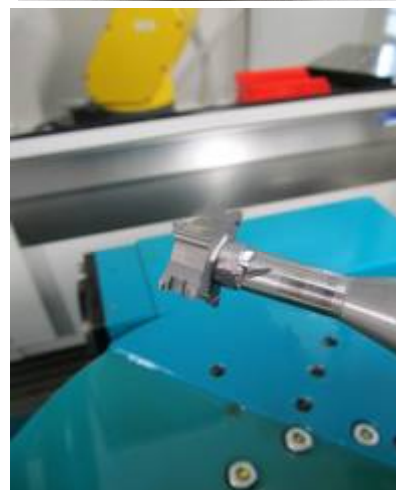
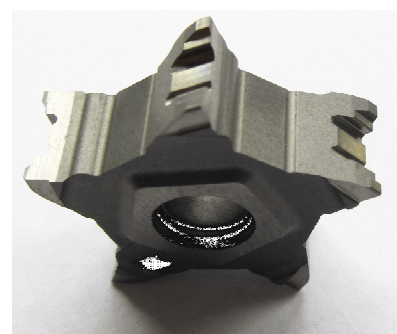


Turning Insert width 10mm








A08-250

The turning insert with 5 cutting edges is probed on all the 5 references sides to assign the corresponding position of the an edge with respect to its reference faces. Using the TTC Pin-Clamping, all process are applicable in one setup: chipbreaker grinding, Profile pre- and finishgrinding.

Programming and Simulation time: 20 Min., Setuptime for good tool: 30 Min. (wheels and clamping device already in use for previous tools)



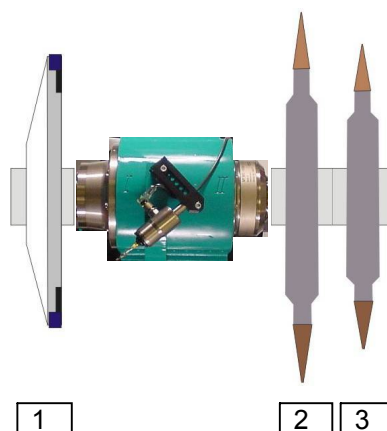
1. Cycletime for Production

Workpiece: Z5, H15 mm, T 10 mm Material CARBIDE				
Operations				
Feed [mm/Min]	2000	100	35	60
Power [kW]		1	4	2
Cutting speed [m/s]		22	22	22
Used wheels				
Grinding time [s]	30	193	300	186
Total cycle time	11 Min 49			

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	12C9 Ø250 D64
2	14EE1 Ø250 D76V20°
3	14EE1 Ø200 D54V20°



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : SIRIUS HPM
Control: Fanuc 31iA5
Accessories: TTC

Coolant: Synthetic Oil, pressure 6 bar
Software: Quinto 5

Responsible engineer: OP. 3.7.12

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J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland
Subsidiaries in: France, Deutschland, Italia, United States, UK, China